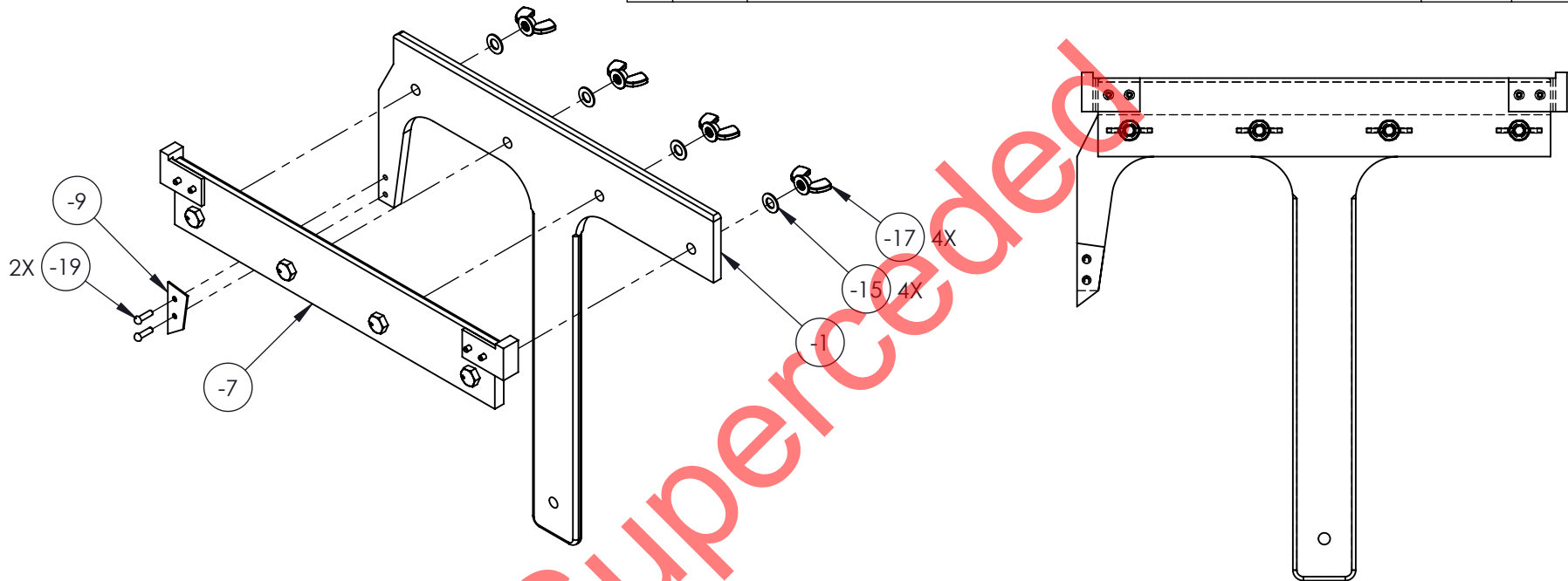


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TEO ATTACHED

REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
A		CH'D TITLEBLOCK & REVISION BLOCK, CH'D DWG. NO. FROM 407-215-001-101, CH'D DESCRIPTION IN BOM P/N -1, -3, -4, -5.	6/18/2009	RJC	
1		ADDED -9 & -19, CH'D DESIGN -1 PER S.E. SEPARATED PARTS TO INDIVIDUAL SHEETS, CREATED ASSY. DWG. & -7 ASSY. DWG.	4/27/2011	RJC	
2		CH'D -1 CHAMFER FROM 1/16 & CH'D FINISH FROM POWDER COAT YELLOW ADDED -5 FINISH PER R.W. MOVED #30 HOLE TO BE SYMETRICAL WITH RIGHT SIDE PER S.E. DELETED -7 FINISH & NOTE 2 PER R.W.	8/25/2011	RJC	RW
3		-1 CH'D TWO HOLES DIM'S, WAS R.064 (x2) IS Ø.125 (X2).	12/26/2013	RJC	GE
4	15-0021	UPDATED TO NEW DRAFTING STANDARDS. -1 CH'D DIM WAS .250 IS (.250). -3, -4 CH'D DIMS WAS DRILL #30 THRU X2 IS 2X Ø.129 THRU, WAS .500 IS (.500). -5 CH'D DIM WAS DRILL #30 THRU CSK 100° X .24 OD 4 PLACES IS 4X Ø.129 THRU ✓ Ø.24 X 100°. -7 CH'D DIM WAS 11.580 IS (11.580). -9 CH'D DIMS WAS 1.051 IS (1.051), WAS .801 IS (.842), WAS .301 IS .347. ADDED DIMS (.311), (.381), .500. CH'D TOLERANCE ON NON-CRITICAL DIMENSIONS.	1/26/2015	DPD	JAG

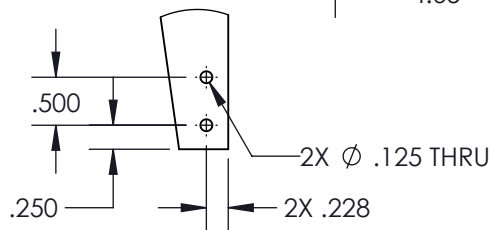
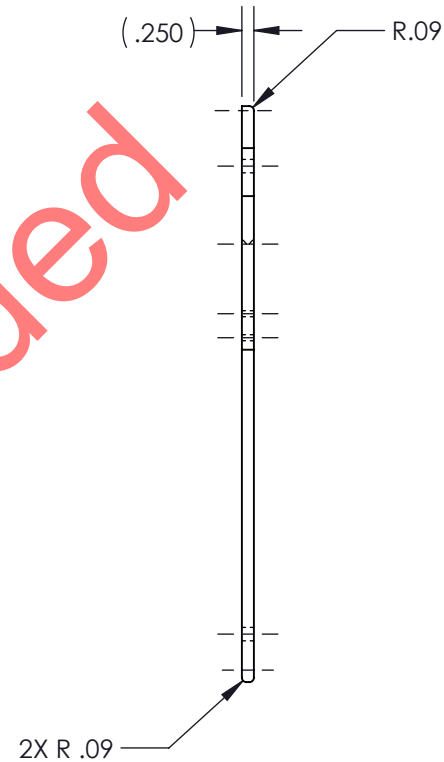
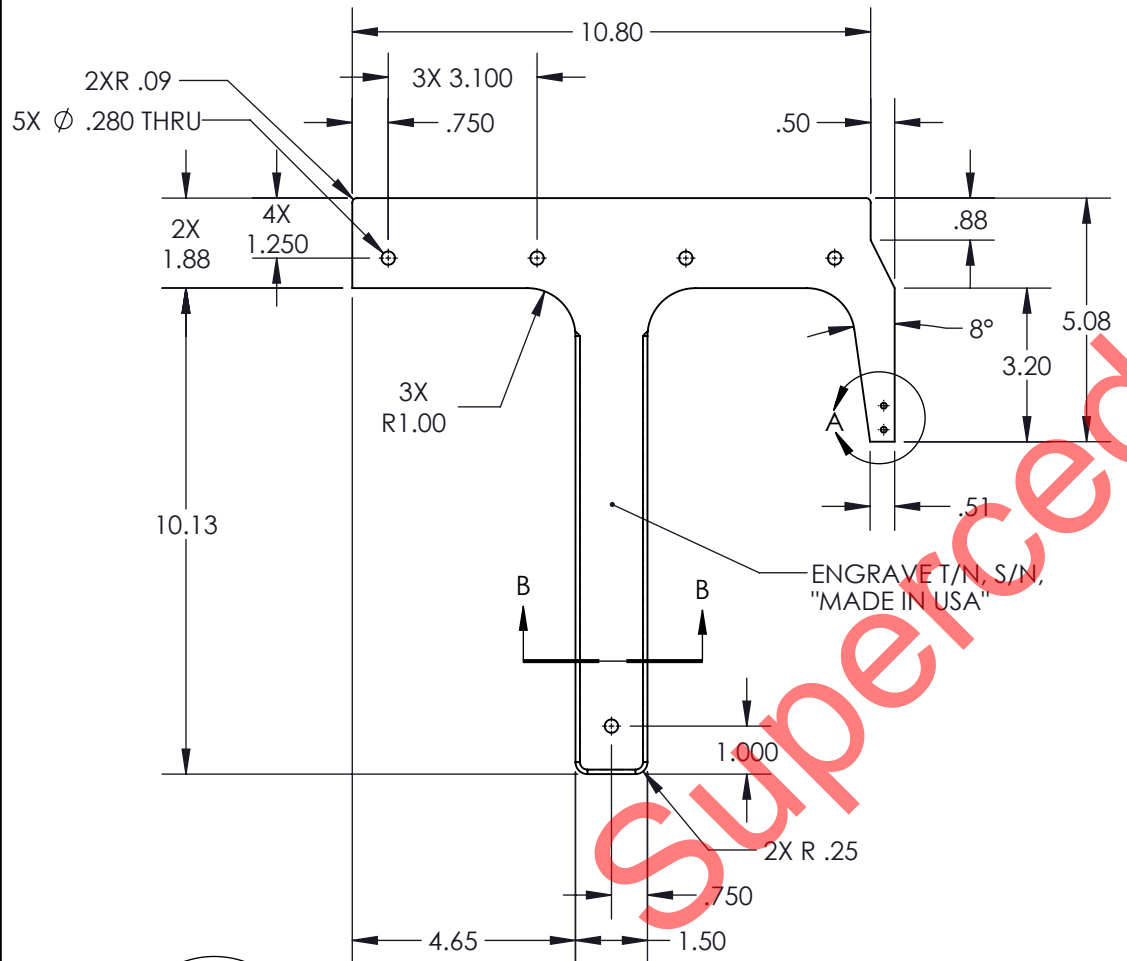


ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
			-1	1	TAB BENDER BODY	6061		2
	1		-3		LEFT CLAMP	2024 OR 6061		3
	1		-4		RIGHT CLAMP	2024 OR 6061		4
	1		-5		TOP TAB	2024 OR 6061		5
	X		-7	1	TOP TAB ASSY			6
			-9	1	POINTER	304		7
	4	B/O	-11		C.S. HEAD RIVET	ALUMINUM	Ø1/8 X 1/2, 100° (AIRCRAFT SPRUCE #AN426AD-4-8)	6
	4	B/O	-13		BOLTS	STEEL	1/4-28 UNF X 1-1/32 (AIRCRAFT SPRUCE #AN4-10A)	6
		B/O	-15	4	WASHERS	STEEL	Ø1/4 (AIRCRAFT SPRUCE #AN960-416L)	1
		B/O	-17	4	WINGNUTS	STEEL	1/4-28 UNF (AIRCRAFT SPRUCE #AN350-4)	1
		B/O	-19	2	UNIVERSAL HEAD RIVET	ALUMINUM	Ø1/8 X 7/16 (AIRCRAFT SPRUCE #AN470AD-4-7)	1
	ASSY -7							

<b>DART</b> AEROSPACE	
TITLE TRIM TAB BENDER	
DWG NO. RBT400213	REV 4
MAT'L UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 .XX ± .01 .X ± .1	DRAWN BY: COLE APPROVED D Weil HEAT TREAT FINISH SPEC
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE 1:4	DATE 8/22/2000
SHEET 1 OF 7	

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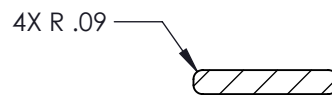
REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2		CH'D -1 CHAMFER FROM 1/16 & CH'D FINISH FROM POWDER COAT YELLOW PER R.W.	8/25/2011	RJC	RW
3		-1 CH'D TWO HOLES DIM'S, WAS R.064 (x2) IS Ø.125 (X2).	12/26/2013	RJC	GE
4	15-0021	-1 CH'D DIM WAS .250 IS (.250).	1/26/2015	DPD	JAG



DETAIL A  
SCALE 1 : 2

(-1)

TAB BENDER BODY

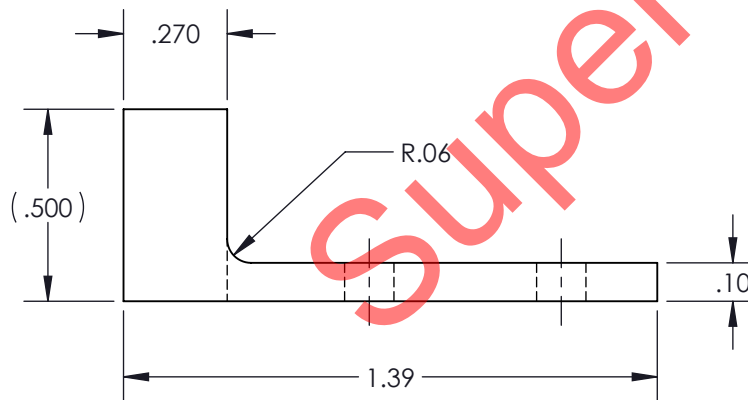
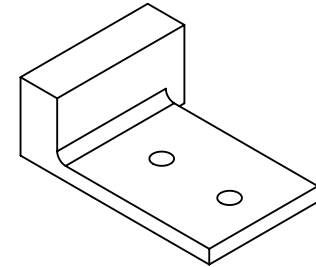
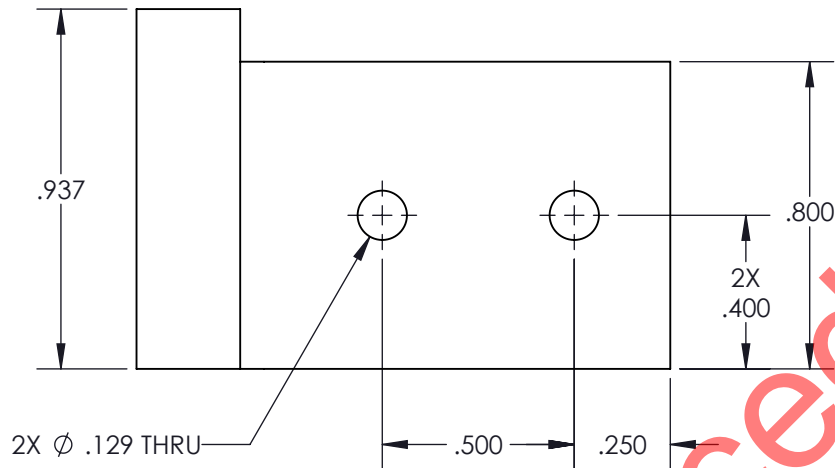


SECTION B-B  
SCALE 1 : 2

<b>DART AEROSPACE</b>	
TITLE <b>TRIM TAB BENDER</b>	
DWG NO. <b>RBT400213-1</b>	REV <b>4</b>
MAT'L 6061	DRAWN BY: <b>COLE</b>
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	APPROVED <i>D Weil</i>
.XXX ± .005 FRACTIONS ± 1/8	HEAT TREAT
.XX ± .01 ANGLES ± .5°	FINISH RED ANODIZE
.X ± .1	SPEC MIL-A-8625F, TYPE II, CLASS II
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	USED ON MODEL
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	<b>BELL 407</b>
SCALE 1:4	DATE 8/22/2000
SHEET 2 OF 7	

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
4	15-0021	-3 CH'D DIMS WAS DRILL #30 THRU X2 IS 2X Ø.129 THRU, WAS .500 IS (.500).	1/26/2015	DPD	JAG



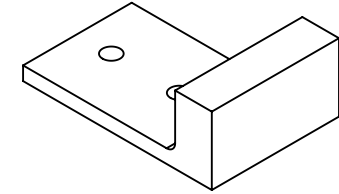
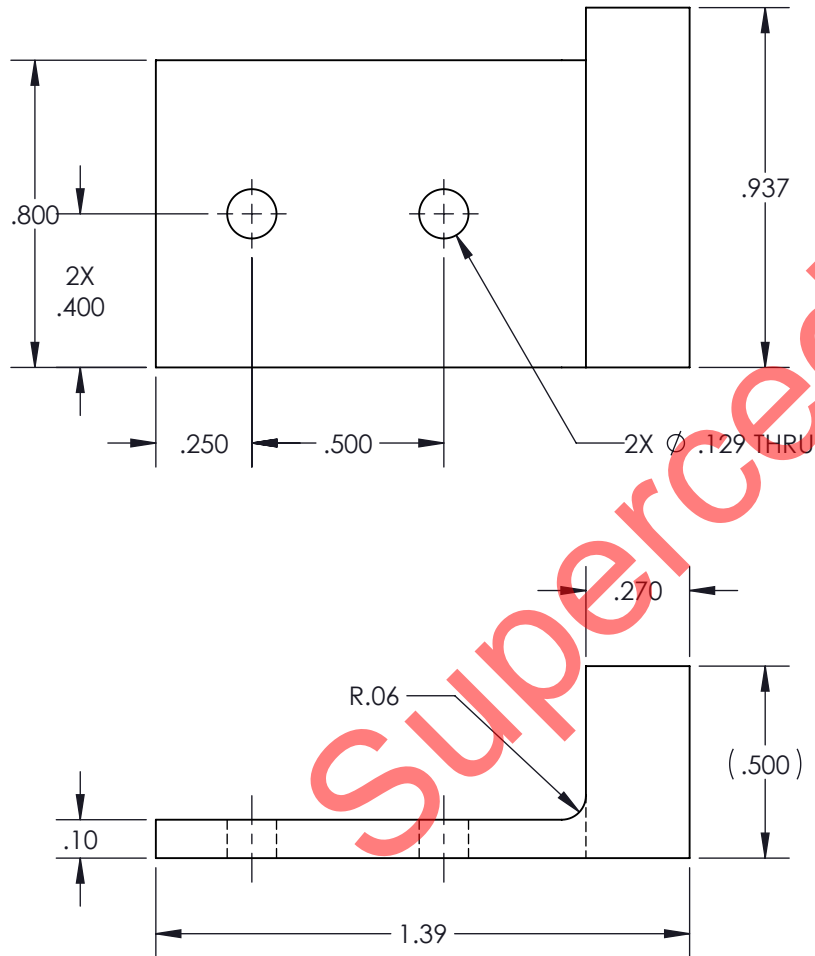
(-3)

LEFT CLAMP

<b>DART</b> AEROSPACE	
TITLE TRIM TAB BENDER	
DWG NO. RBT400213-3	REV 4
MAT'L 2024 OR 6061	DRAWN BY: COLE
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	APPROVED <i>D Weil</i>
.XXX ± .005 FRACTIONS ± 1/8	HEAT TREAT
.XX ± .01 ANGLES ± 5°	FINISH RED ANODIZE
.X ± .1	SPEC MIL-A-8625F, TYPE II, CLASS II
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	USED ON MODEL
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	BELL 407
SCALE 2:1	DATE 8/22/2000
SHEET 3 OF 7	

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
4	15-0021	-4 CH'D DIMS WAS DRILL #30 THRU X2 IS 2X Ø.129 THRU, WAS .500 IS (.500).	1/26/2015	DPD	JAG

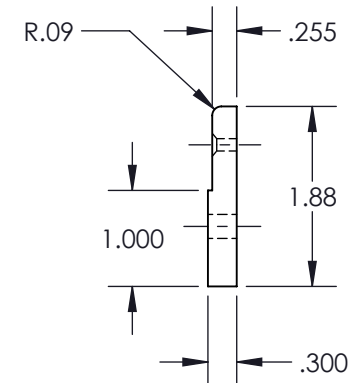
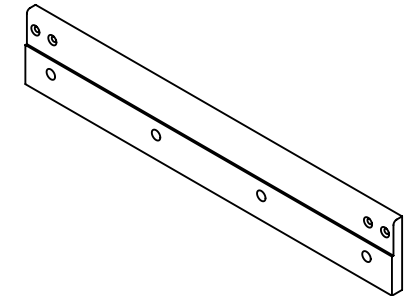
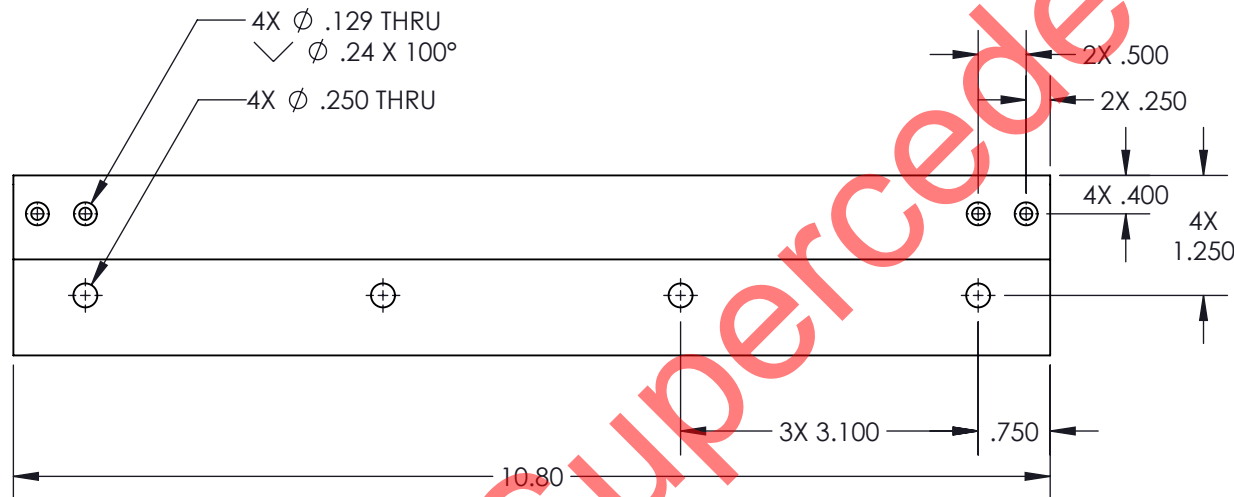


(-4)  
RIGHT CLAMP

<b>DART AEROSPACE</b>	
TITLE <b>TRIM TAB BENDER</b>	
DWG NO. <b>RBT400213-4</b>	REV <b>4</b>
MAT'L 2024 OR 6061	DRAWN BY: COLE
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	APPROVED <i>D Weil</i>
.XXX ± .005 FRACTIONS ± 1/8	HEAT TREAT
.XX ± .01 ANGLES ± .5°	FINISH RED ANODIZE
.X ± .1	SPEC MIL-A-8625F, TYPE II, CLASS II
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	USED ON MODEL
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	BELL 407
SCALE 2:1	DATE 8/22/2000
SHEET 4 OF 7	

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2		ADDED -5 FINISH, PER R.W. MOVED #30 HOLE TO BE SYMENTRICAL WITH RIGHT SIDE PER S.E.	8/25/2011	RJC	RW
4	15-0021	-5 CH'D DIM WAS DRILL #30 THRU CSK 100° X .24 OD 4 PLACES IS 4X Ø.129 THRU ✓ Ø.24 X 100°.	1/26/2015	DPD	JAG

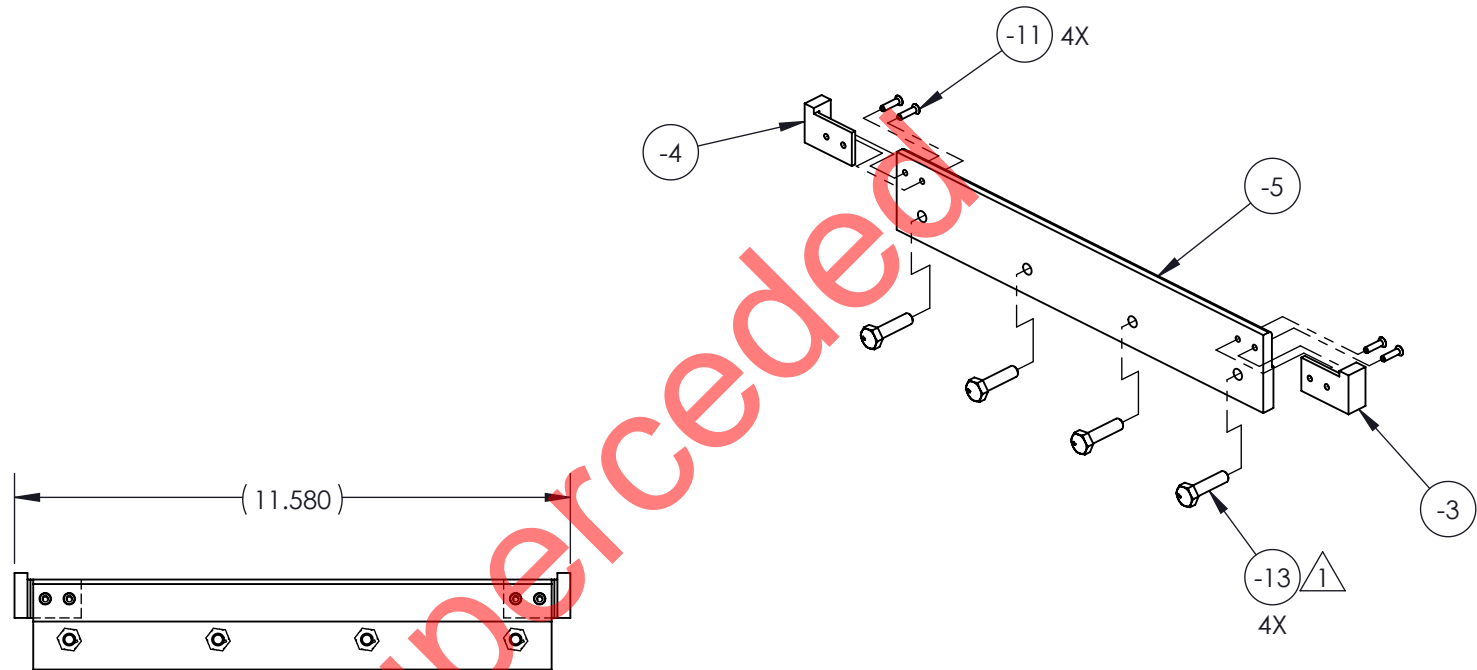


(-5)  
TOP TAB

<b>DART</b> AEROSPACE	
TITLE TRIM TAB BENDER	
DWG NO. RBT400213-5	REV 4
MAT'L 2024 OR 6061	DRAWN BY: COLE
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	APPROVED <i>D Weil</i>
.XXX ± .005 FRACTIONS ± 1/8	HEAT TREAT
.XX ± .01 ANGLES ± 5°	FINISH RED ANODIZE
.X ± .1	SPEC MIL-A-8625F, TYPE II, CLASS II
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	USED ON MODEL
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	BELL 407
SCALE 1:2	DATE 8/22/2000
SHEET 5 OF 7	

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
4	15-0021	-7 CH'D DIM WAS 11.580 IS (11.580).	1/26/2015	DPD	JAG



NOTE:

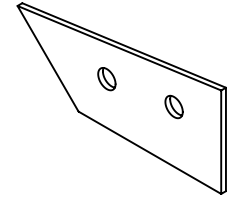
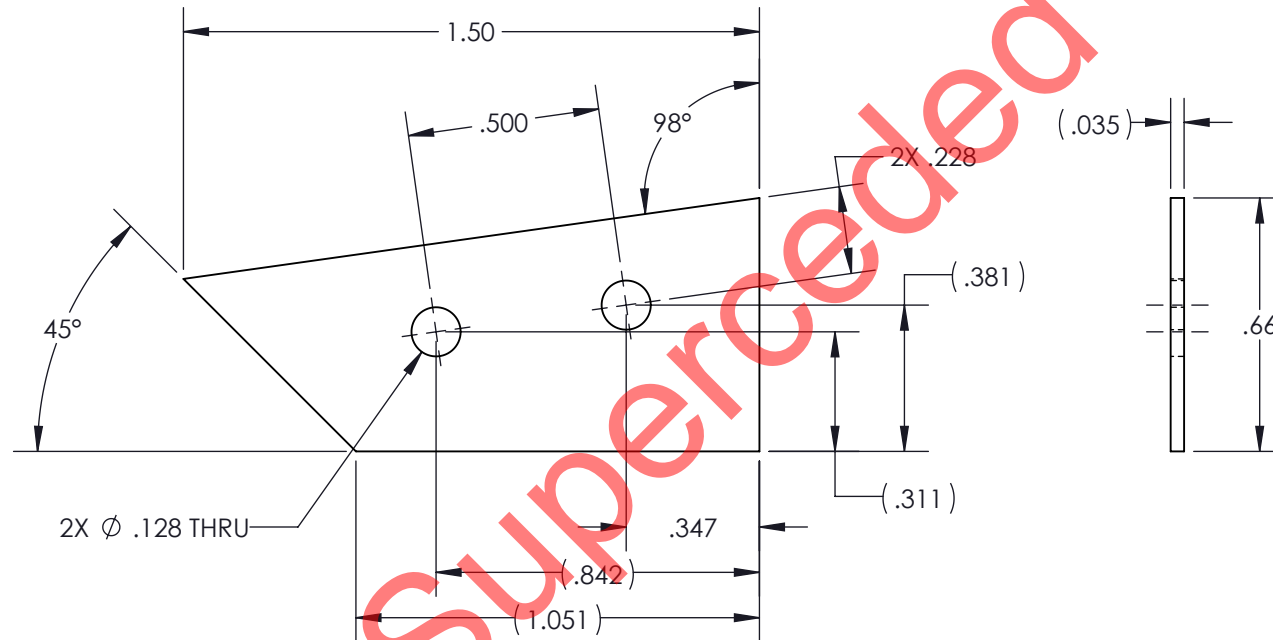
- 1 EPOXY BOLT HEADS & 1/4" OF SHANK TO -5.  
CLEAN OFF EXCESS.

(-7)  
TOP TAB ASSY

<b>DART</b> AEROSPACE	
TITLE TRIM TAB BENDER	
DWG NO. RBT400213-7	REV 4
MAT'L UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± 5° .X ± .1	DRAWN BY: COLE APPROVED <i>D Weil</i> HEAT TREAT FINISH SPEC
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	USED ON MODEL BELL 407
SCALE 1:4	DATE 8/22/2000
SHEET 6 OF 7	

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1		ADDED -9.	4/27/2011	RJC	
4	15-0021	-9 CH'D DIMS WAS 1.051 IS (1.051), WAS .801 IS (.842), WAS .301 IS .347. ADDED DIMS (.311),(.381), .500.	1/26/2015	DPD	JAG



⑨  
POINTER

<b>DART AEROSPACE</b>	
TITLE <b>TRIM TAB BENDER</b>	
DWG NO. <b>RBT400213-9</b>	REV <b>4</b>
MAT'L 304	DRAWN BY: COLE
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	APPROVED <i>D Weil</i>
.XXX ± .005 FRACTIONS ± 1/8	HEAT TREAT
.XX ± .01 ANGLES ± 5°	FINISH
.X ± .1	SPEC
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	USED ON MODEL
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	BELL 407
SCALE 2:1	DATE 8/22/2000
SHEET 7 OF 7	



ENGINEERING ORDER # TEO17-642

SCALE: NTS

SHEET 1 OF 1

DRAWING NO. RBT400213

REV: ~~NC~~ 4

EFF.: NEXT ORDER

CHANGE CATEGORY

☐ MAJOR ☒ MINOR

DATE 17.09.07

TITLE: TRIM TAB BENDER

APPROVED: VM 09/15/2017

QA APP.: PD 09/14/2017

MFG. APPR.: DP 09/11/2017

CHECKED: SAC 09/08/2017

DRAWN: VM 09/08/2017

TRANSACTION CODE (TC):

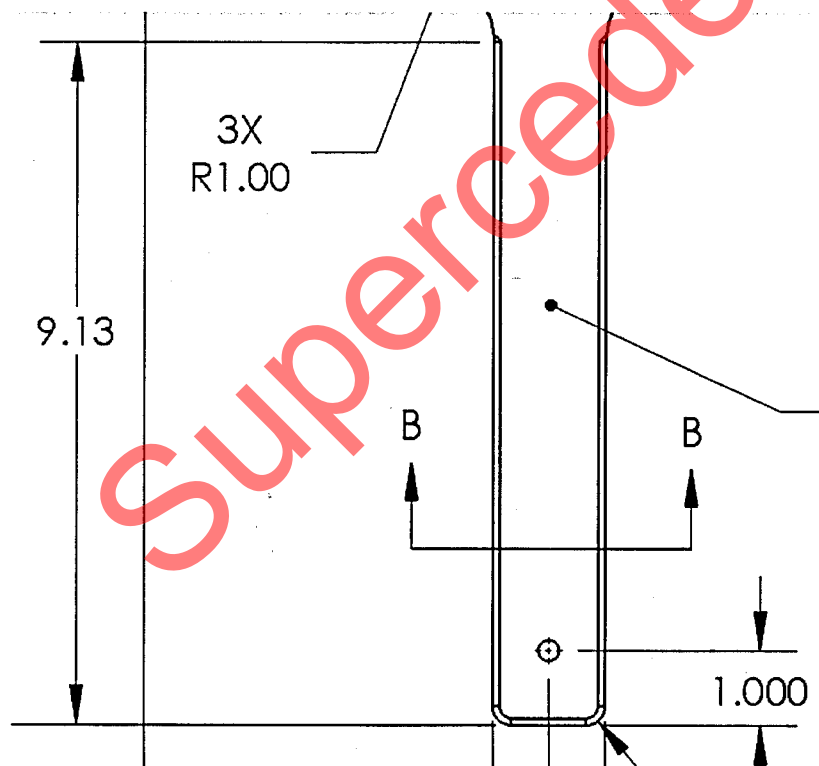
A-ADD C-CREATE  
R-REVISE D-DELETE

REASON: MISSING DIMENSION

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WAS : PART# RBT400213-1 Rev 4 LENGTH DIMENSION FOR THE RADIUS  
IS : PART# RBT400213-1 Rev 4 LENGTH DIMENSION 9.13"



DOCUMENTS EFFECTED: ☐ PATTERN ☐ INSTALL INSTRUCTIONS ☐ BOM

ECN 17-642